

Work Order ID 84322 -2

May-09-12 2:37:37 PM

Ship ASAP

84322

Page 1

Item ID: D206-817-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Screw-In Windshield, LH/RH

Start Date: 5/09/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/15/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

u

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D206-817

C

100

0.00

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D206-817-011 CHG002

DAS 16 8-83 12/05/12 12/05/11

12/05/12

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

2

12/05/13 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS 16 8-83 12/05/12 12/05/11

Work Order ID 84322

84322

Page:2

May-09-12 2:37:37 PM

Item ID: D206-817-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Screw-In Windshield, LH/RH
 Start Date: 5/09/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/15/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-817-011 Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten signature: 12/8/12 @ 12/27/12

Handwritten: MW 12/07/12

Handwritten: ME 12-07-20

Picklist Print

May-09-12 2:37:35 PM

Page 1

Work Order ID: 84322

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 5/09/12

Required Date: 5/15/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.02.14 NEW ISSUE DD VERF:
REV.C DD VERF:EC

IPP REV:B 12.05.09 AS PER IIN

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-5 Bracket		Manufactured	No			110	Each	2.0000	1	2	✓	JB	SP
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		2							
				78277		2							
D4541-6 Bracket		Manufactured	No			110	Each	0.0000	1	2	✓	JB	SP
D4542-5 Retainer, Inner		Manufactured	No			110	Each	3.0000	2	4	✓	JB	SP
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		2							
				78281		2							
				GA		1							
				81268		1							
MS20426AD3-4 RIVET		Purchased	No			110	Each	3,280.0000	24	48	✓	JB	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		3280							
				104374		614							
				110398		2666							
MS21059L3K Nutplate		Purchased	No			110	Each	314.0000	12	24	✓	JB	12/05/22
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST302		314							
				121114		314							

Picklist Print

May-09-12 2:37:35 PM

Page 2

Work Order ID: 84322

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 5/09/12

Required Date: 5/15/12

Start Qty: 2.00

Required Qty: 2.00

D4543-1
Retainer, Outer, LH

Manufactured No

110 Each 2.0000

1 84267 2 ✓ JB 50

Location

Loc Qty

Loc Code

st151

2

80493

2

D4543-2
Retainer, Outer, RH

Manufactured No

110 Each 2.0000

1 84268 2 ✓ JB 50

Location

Loc Qty

Loc Code

st151

2

80494

2

D4543-3
Retainer, Outer, LH

Manufactured No

110 Each 1.0000

1 84269 2 ✓ JB 50

Location

Loc Qty

Loc Code

ST157

1

80495

1

D4543-4
Retainer, Outer, RH

Manufactured No

110 Each 2.0000

1 84270 2 ✓ JB 50

Location

Loc Qty

Loc Code

st151

2

80496

2

D4544-1
Retainer, Center

Manufactured No

110 Each 1.0000

1 84271 2 1X 84271 ✓ JB 50

Location

Loc Qty

Loc Code

hai

1

79386

1

D4545-041
Retainer, Inner, LH (Lower)

Manufactured No

110 Each 0.0000

1 84170 2 1X 84170 ✓ JB 50

D4545-042
Retainer, Inner, RH (Lower)

Manufactured No

110 Each 0.0000

1 84169 2 1X 84169 ✓ JB 50

D4545-043
Retainer, Inner, LH (Side)

Manufactured No

110 Each 0.0000

1 84272 2 1X 84272 ✓ JB 50

D4545-044
Retainer, Inner, RH (Side)

Manufactured No

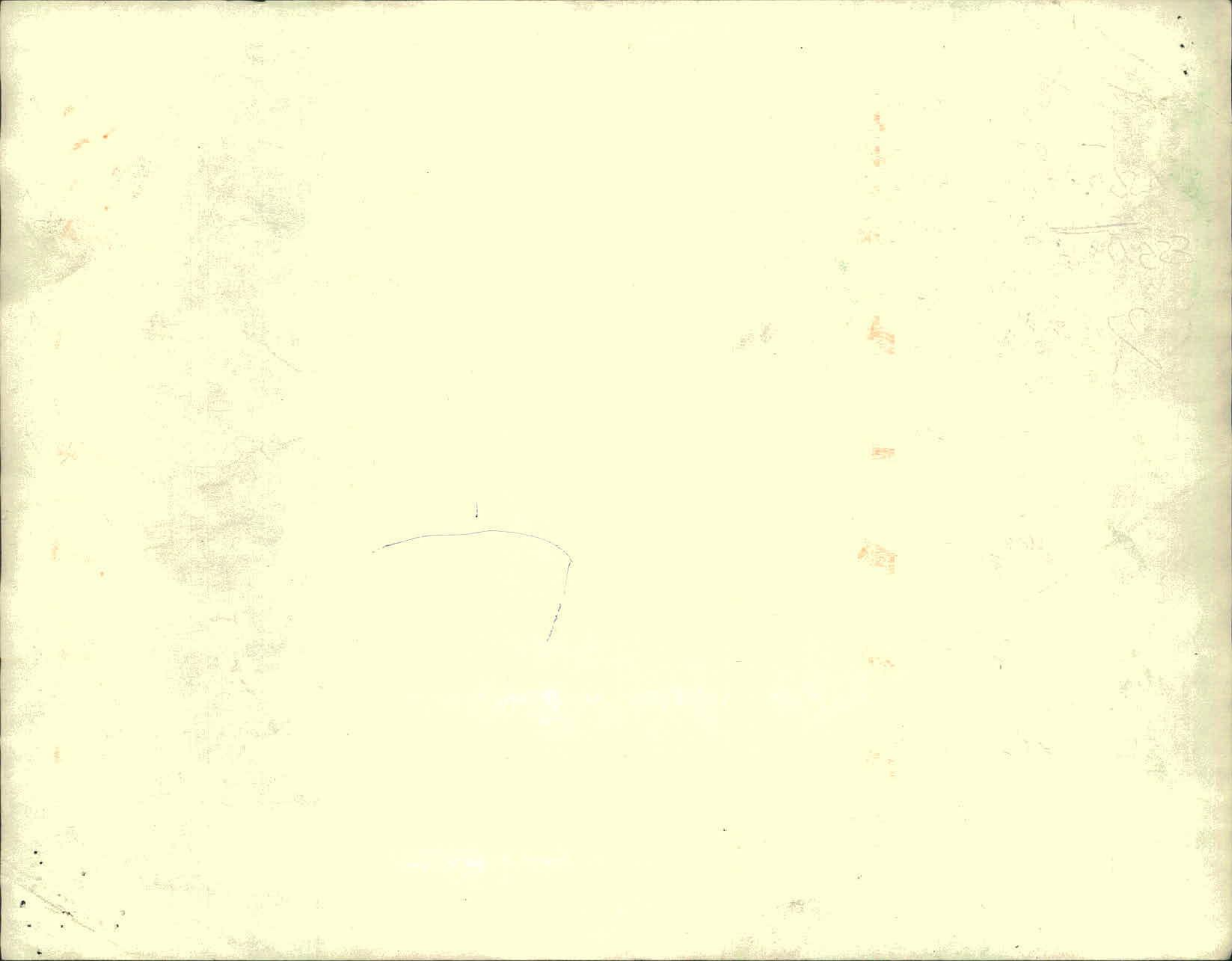
110 Each 0.0000

1 84273 2 1X 84273 ✓ JB 50

May-09-12 2:37:36 PM

Shop Packet Print

Page 2



Picklist Print

May-09-12 2:37:36 PM

Page 3

Work Order ID: 84322

Parent Item: D206-817-011

Start Date: 5/09/12

Required Date: 5/15/12

Parent Item Name: Screw-In Windshield, LH/RH

Start Qty: 2.00

Required Qty: 2.00

D4545-045	Manufactured	No	110	Each	0.0000	1	2
Retainer, Inner, LH (Top Corner)							
D4545-046	Manufactured	No	110	Each	0.0000	1	2
Retainer, Inner, RH (Top Corner)							
D4545-047	Manufactured	No	110	Each	0.0000	1	2
Retainer, Inner, LH (Top)							
D4545-048	Manufactured	No	110	Each	0.0000	1	2
Retainer, Inner, RH (Top)							
D4594-1	Manufactured	No	110	Each	1.0000	1	2
Plate							

Location

Loc Qty

Loc Code

ST139A

1

80506

1

D4595-150-25

Manufactured No

110

Each

0.0000

2

Sealant Tape

AN525-10R

Screw

Purchased No

110

Each

453.0000

190

Location

Loc Qty

Loc Code

ST345

453

115371

7

116737

44

118686

100

120833

2

121390

300

MS210591.08

Nut

Purchased No

110

Each

162.0000

23

46

Location

Loc Qty

Loc Code

ST300

162

112314

160

12706

2

May-09-12 2:37:36 PM

Shop Packet Print

Page 3



Picklist Print

May-09-12 2:37:36 PM

Page 4

Work Order ID: 84322

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 5/09/12

Required Date: 5/15/12

Start Qty: 2.00

Required Qty: 2.00

MS21075L08

Purchased

No

110

Each

164.0000

1

2

ANCHOR NUT

Location

Loc Qty

Loc Code

ST303

35

111578

2

120560

33

ST304

99

121255

49

121556

50

ST308

30

120930

30

MS27039-08-10

Purchased

No

110

Each

146.0000

22

44

Screw

Location

Loc Qty

Loc Code

Mezz

146

5865

146

NAS1149DN832J

Purchased

No

110

Each

1,409.0000

22

44

WASHER

Location

Loc Qty

Loc Code

ST298

1409

119717

41

120422

1368

May-09-12 2:37:36 PM

Shop Packet Print

Page 4

PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-5	BRACKET, LH
1	D4541-6	BRACKET, RH
2	D4542-5	RETAINER, INNER
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4545-043	RETAINER, LH INNER (SIDE)
1	D4545-044	RETAINER, RH INNER (SIDE)
1	D4545-047	RETAINER, LH INNER (TOP)
1	D4545-048	RETAINER, RH INNER (TOP)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
95	AN525-10R7	SCREW
24	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
12	MS21059L3K	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)

4.0 WEIGHT AND BALANCE

The weight and balance for the D206-817-011 kit is as follows. These are net weights and include the parts removed.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D206-817-011	2.8 lb	40 in	112 in-lb
Screw-In Windshield Modification Kit	1.3 kg	1.0 m	1.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-5	BRACKET, LH
1	D4541-6	BRACKET, RH
2	D4542-5	RETAINER, INNER
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4545-043	RETAINER, LH INNER (SIDE)
1	D4545-044	RETAINER, RH INNER (SIDE)
1	D4545-047	RETAINER, LH INNER (TOP)
1	D4545-048	RETAINER, RH INNER (TOP)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
95	AN525-10R7	SCREW
24	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
12	MS21059L3K	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)

